

Process Sheet

mer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT

Job Number: 40606

Part Number: PB674300111

Job Number:



Seq. #:	Machine Or Operation:	Description :
20.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		S00/0/23 @
21.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1		
Identify and Stock		
Location: _____		cart welding S00/0/23 @2
22.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		

Job Completion



MF 08-10-23



Process Sheet

mer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40606

Part Number: PB674300111

Job Number:



Seq. #:	Machine Or Operation:	Description :
	START TIME: <u>2:30</u> OVEN TEMPERATURE: <u>320 °F</u> FINISH TIME: <u>3:00</u>	<u>5X</u> <u>08/07/31</u> <u>m-h</u>
14.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		<u>FL</u> <u>08/07/31</u> <u>(5)</u>
15.0	PB674300169 	90 Degree Cover Plate
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) 90 Degree Cover Plate batch: <u>40069</u>		<u>was done for</u> <u>only 2 only</u> <u>see split</u> <u>08.08.26</u>
16.0	PB674300183 	PB67-43001-83
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) PB67-43001-83 batch: <u>40096</u>		<u>08.08.26</u>
17.0	MS27039110 	Screw
Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s) Screw batch: <u>18836</u>		<u>08.08.26</u>
18.0	NAS1149F0316P 	WASHER
Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s) WASHER batch: <u>106742</u> <u>108900</u>		<u>08.08.26</u>
19.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1- match drill cover to existing holes in support 2- assemble as per dwg		<u>08.08.26</u>

Process Sheet

Order Number: CU-DAR001 Dart Helicopters Services

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Seq. #: Machine Or Operation: Description :

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
1- make a 0.090" chamfer in the 1.00" hole before welding
2- assemble parts and weld as per dwg

08-07-22

7.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08-07-24(5)

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/26 (X) 08-07-29

9.0 MS124780 HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)
HELICAL INSERT

17935

08-07-29

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- grind weld flush in area of PB67-43001-249 only
2- tap drill for helicol
3- install helicol insert as per dwg

08-07-29 (5)

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/07/29 (5)

12.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

N/A

13.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

M 102316

(5X)

1- MASK TUBE FROM BASE TO GUSSET

08-07-31

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

08/07/31

Date: Thursday, 24/07/2008 8:20:48 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FWD ADJUSTABLE BLADE SUPPORT ASSY
 Job Number : 40606 - 1
 Estimate Number : 13435
 P.O. Number :
 This Issue : 24/07/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 17/07/2008 Type : LARGE FAB ASSY
 Previous Run :
 Written By :
 Checked & Approved By : MF 08-07-24
 Comment : Est Rev:A 08-06-26 new issue DD verified by:ec

Part Number : PB674300111
 Drawing Number : B6743001 P.8
 Project Number : N/A
 Drawing Revision : B1
 Material :
 Due Date : 24/07/2008

Qty: 5 Um: Ea

Duplicate split 2

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PB6743001247 Inner Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Inner Tube

batch: 340689

MF 08-07-24

2.0 PB6743001249 Inner Tube Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Inner Tube Bushing

batch: 10537

MF 08-07-24

3.0 PB6743001253 Gusset



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Gusset

batch: 340045

MF 08-07-24

4.0 PB6743001254 Gusset



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Gusset

batch: 340053

MF 08-07-24

5.0 PB674300167 PB67-43001-67



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

PB67-43001-67

batch: 340243

MF 08-07-24